Work Orde		5294		*106	294*						Page 1
Item ID: Revision ID: Item Name:	D2174-041 Web Assembly			Accept	*N900	<u>040</u>	100) *	Setup Sta	1.7	S1* S2*
Start Date: Required Date: Reference:	8/28/13 8/28/13	Start Qty: 3.00 Req'd Qty: 3.00	*3* *3*		Cust Item l Customer:	D:				1 4	
Approvals:		n: <u>M</u> L5	Date: 13-08-29	Tooling: SPC (Y/N):		ate:		I	Run Sta St	I \	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.
Draw Nbr	Revi	ision Nbr									
D2174	Rev	E									/ / 8
*1\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\		Small Fab Memo 1- Assemble	as per Dwg D2174-0412- Io	0.00 0.00 dentify as D2174-041			(3×			13/11/14
110 *110* QC Quality Control		QC5- Inspect part comple	eteness to step on W/O	DAS 27 0.00 9-89 3-11-15				3		_	
120 *120* Powdercoat Powder Coating		White Gloss(New 4-25-1) Memo START TIM	Lia	0.00 0.00 OVEN TEMPERATURE	i:			3 9	b	3-/ <i>1-1</i> 8 .	DAS 34 9-89

					•					DQA:	Date	:	
NCR:	Yes / N	o			WORK ORDER NON-C	100	NFORM						
										QA Closed:	Date	:	
Work Orde	er.				DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS		
Part N				······································	Rework Scrap		Skid-tube Crosstube Machining Small Fab			1	Water Jet d. Eng. Coor.	Engineering Quality	
NCR I	No				Use-as-is Work Order Update		Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other	
Root	i			Descri	ption of work order update		Initial	Ac	tion	Sign &			
Cause	Dat	e Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data							:						
Equip/Tooling						Ì							
Operator													
Material				1,									
Setup										•			
Other													
Process													
Supplier			-			ļ							
Training		1											
Unapproved						<u> </u>							
		. 		- 11	F/	AUL	T CATE	GORY					
Landi	ng Gear				General		_			_		_	
	Bend	ng			Bend	L	Grain			Ovalized		Pressure/Forced	
	Centr	e Not Conc	entric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure	
	Cracks Broken/Damaged						Inspecti	ion Incomplete		Part Incorre	ct 🗍	Weld	
	Crushed/Crimped Burrs						Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs				Contamination					Part Moved		_	
	Heat	Γreat			Countersink		⊣ ⊢				Positioned Wrong		
	Inspection Strip in Tube Cut Too Short						Misread	Misread Power Loss/Surge Oth					

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde		6294		*10	6294*						Page 2	
Item ID: Revision ID:	D2174-041			Accept	*N900	040	100)* s	Setup Sta	rt *	JS1*	-
Item Name:	Web Assembly	y							Sto	p *	JS2 *	
Start Date: Required Date: Reference:	8/28/13 8/28/13	Start Qty: 3.00 Req'd Qty: 3.00	*3* *3*		Cust Item I Customer:	D:				-		
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:	_	F	Run Sta Sto]\ 	JR1* JR2*	
Sequence ID/ Work Center II	D	Operation Description QC3- Inspect Part Finish		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Numbe	Insp.	
130 QC Quality Control		Memo		0.00				J /			_ 3/11/17	7 º,
¹⁴⁰ *1⊿∩*		Small Fab		0.00				$\mathcal{B}_{\!\scriptscriptstyle imes}$			13/11/1	/ .50.
Small Fab Small Fab		Memo Install nuts &	bolts loosely as per Dwg	0.00 g D2274								/ <i>36</i> 9.8 _©
150		OC5- Inspect part comple	teness to step on W/O	0.00	AS							

150

Quality Control

Memo

											DQA:	Date	::		
NCR:	⁄es	/ No				WORK ORDER NON-C	COI	NFORM	MANCE / UPD	ATE					
											QA Closed:	Date	2:		
Work Orde	٠.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS			
WORK OTG	۲۱.					Rework	1		Skid-tube	Crosstube	İ	Water Jet	Engineering		
Part I	۷o.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
	•					Use-as-is			noforming	Finishing	ı	re/Packaging	Other		
NCR I	۷o.					Work Order Update]		Large Fab	Composite		Supplier			
			1	1		<u></u>							· · · · · · · · · · · · · · · · · · ·		
Root						ption of work order update		Initial	Actio		Sign &	_			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descrip	otion	Date	Verification	QC Inspector		
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Operator	<u> </u>						İ								
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Setup	_				12										
Other	\vdash				` .								1		
Process Supplier	\vdash		İ												
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Unapproved	_														
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Landi	ng (Gear			" was " we	General									
		Bending				Bend		Grain			Ovalized		Pressure/Forced		
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure		
İ	⊢					Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld		
	Crushed/Crimped Burrs					Burrs		Instruct	ions Incomplete/Ur	nclear	Part Lost/Mi	Wrong Stock Pulled			
		Cuffs			<u> </u>	Contamination	Maintenance					Part Moved			
						Countersink		Mislabe	eled		Positioned V	_			
	1	Inspection	n Strin in	Tuhe		Cut Too Short		Misread	4		Power Loss/	Surge I	Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

W	ork	Order	ID	106294
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106294

Page 3

August-28-13 1	2:35:35 PM			1111	1/94		_					rage 3
Item ID: Revision ID:	D2174-041		1	Accept	*N900	040	100)* s	Setup St	art	*N:	S1*
Item Name:	Web Assembly	y							St	top	*N!	S 2*
Start Date:	8/28/13	Start Qty: 3.00	*3*		Cust Item 1	D:						
Required Date: Reference:	: 8/28/13	Req'd Qty: 3.00	*3*		Customer:							
Approvals:	Process Pla	n:	Date:	Tooling:	D	ate:		R			*NI	₹1*
	QC:		Date:	SPC (Y/N):	D	ate:			St	top	*NI	₹2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		ject mber	Insp. Stamp
160		Identify as per dwg & St	ock Location: <u>572</u> 40	0.00				_				
160 Packaging Packaging		Memo		0.00				3x	DAS 28 9-89	_/3	5-11-	-19
170		QC21- Final Inspection	- Work Order Release	0.00					401		21	49
*17 0 *				0.00			_	<u> </u>	121	<u> [[]</u>	21	10
QC Quality Control		Мето		0.00					. 1		J	MF 13/11-20

										DQA:	Date:	
NCR: Ye	es ,	/ No				WORK ORDER NON-C	ONFOR	MANCE / UP		QA Closed:	Date:	
Work Order	r.					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No	_					Rework Scrap		Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality
NCR No	o			,		Use-as-is Work Order Update	Thern	noforming Large Fab	Finishing Composite	Rec/Stoi	re/Packaging Supplier	Other
Root					Descri	ption of work order update	Initial	Ad	ction	Sign &		·
Cause		Date	Step	Qty	C	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
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Material			-									
Setup				•								
Other												
Process												
Supplier												
Training					1							
Unapproved	7											

Landing G	iear	General				 _
	Bending	Bend	Grain		Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware		Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete		Part Incorrect	Weld
	Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	L	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Maintenance		Part Moved	
	Heat Treat	Countersink	Mislabeled		Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short	Misread		Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Offset		-	
	Torque Waves in Extrusion	Drawing	Out of Calibration			
	Turning Sequence	Finish	Out of Sequence			
	Wave/Twist in Tube	Folio	Outside Dimensions			-

FAULT CATEGORY

Work Order ID: 106294
Parent Item: D2174-041
Parent Item: D2174-041
Parent Item Name: Web Assembly Start Date: 8/28/13 Required Date: 8/28/13 Start Date: 8/28/13 Star
Comments: IPP: D04.06.10Reformat; Changed Step 2KI/JLM IPP Rev:E As per Rev E 06-11-22 JLM
Component Item ID/ Replacement Item ID Replacement Item ID Purch Item Location Location Location Seq ID Measure Hand Qty Issued Status Item Seq ID Measure Hand Qty Issued Status Item Seq ID Measure Hand Qty Issued Item Status Item Seq ID Measure Hand Qty Item Status Item Seq ID Measure Hand Qty Item Status Item Status Item It
Item ID Purch Item Location Location Seq ID Measure Hand Qty Issued Issued Issued
D2174-1 Web Location GA 94959 Manufactured No Manufactured No Manufactured No Manufactured No Manufactured No B/086863\implies ** B/086863\impl
Web Location GA Manufactured No Manufactured No Loc Oty Loc Code 36
$\begin{array}{c ccccccccccccccccccccccccccccccccccc$
94959 4 *D2175-1 Manufactured No 100 Each 0.0000 1 3 *D2175-1* *B1086883\implies ** 3\implies \text{13}\implies \text{13}\implies \text{14} \text{38}
*D2175-1 Manufactured No 100 Each 0.0000 1 3 $3/1/4$ DA 31
D2175-1 B1086883 ** 3/11/14 3
D2175-2 Manufactured No 100 Each 8.0000 1 3
D2175-2 Angle RH **
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>
GA 8 8 - B 106904(3x)
95938 4
MS21042L08 Purchased No 100 Each 3,062.000 4 12 // DAS
MS21042I 08 ** ** ** ** ** ** ** ** **
<u>Loc Qty</u> <u>Loc Code</u>
ST315 1062
$\begin{array}{cccccccccccccccccccccccccccccccccccc$
122814 500
123900 550 1239 00

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												DQA:	0	ate:	
NCR: Y	/es	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE		·			
												QA Closed:	D	ate:	······································
Work Orde		,				DISPOSITION				AGAINST D	ΕF	PARTMENT	/PROCESS		
WORK OTGE	-					Rework	1		Skid-tube	Crosstube	٦		Water Je	et 🗀	Engineering
Part N	No.					Scrap	1	i i	Machining	Small Fab	┨	Pro	d. Eng. Coo	-	Quality
	-					Use-as-is	1		noforming	Finishing	٦	Rec/Stor	re/Packagin	g	Other
NCR N	۷o.					Work Order Update]		Large Fab	Composite	⅃		Supplie	:r	
	 -		1		- ···		_		<u> </u>		_	s: s	<u> </u>		Γ
Root	ŀ		١	٥.	1	ption of work order update	1	Initial		tion	١	Sign &		•	061
Cause		Date	Step	Qty	,	or Non-conformance	Cr	nief Eng	Desc	ription	\dashv	Date	Verificati	on	QC Inspector
Doc/Data	Н														
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Other	$\vdash \vdash$						1								
Process	Н					****									
Supplier	Н		1			•	İ							•	
Training	Ш				Ì							1			
Unapproved			<u> </u>	<u>. </u>	<u> </u>	_		T 64TF			۷		<u> </u>		<u> </u>
						-	AUI	LT CATE	GURY		_				
Landi						General]		Г	\neg	Ovalized			Pressure/Forced
	\vdash	Bending				Bend	-	Grain		-	-4		* - !	\vdash	
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1	\vdash	Cracks			-	Broken/Damaged	\vdash	- 1 '	ion Incomplete		-	Part Incorre		\vdash	i
	Crushed/Crimped Burrs						\vdash					Part Lost/Mi	ssing	L	Wrong Stock Pulled
ı	1 1	Cuffs	Contamination Maintenance							1		Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

August-28-13 12:35:39 PM

Work Order ID: 106294

106294

Parent Item Name: Web Assembly

D2174-041

D2174-041

Location

ST346

AN526C832R14

Parent Item:

Purchased

140

Loc Qty

473

473

Each

Each

Each

Start Qty: 3.00 473.0000

Loc Code

0.0000

12 **

Start Date: 8/28/13

DAS

36

AN526C832R14

Screw

NAS1149DN832 Purchased

Washer

AN960JD8

MS20470AD4-6

Purchased

No

124215

140

140

1,883.000

19 **

**

Required Date: 8/28/13

Required Qty: 3.00

RIVET, UNIVERSAL HEAD

Location	<u>n</u>	Loc Qty	Loc Code
GA		4	
	118927	4	
ST336		1848	
	125654	1500	
	m125807	348	
ST505		31	
	123021	31	

57

											DQA:	Date:	
NCR: Y	⁄es	/ No				WORK ORDER NON-O	100	VFORI	MANCE / UPI	DATE			
		•							•		QA Closed:	Date:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	- . No.					Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab			Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		nitial	Act	tion	Sign &	. <u>-</u> .	
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	Н												
Operator Material	H												
Setup	\vdash												
Other	H												
Process	П		_						-				
Supplier													
Training		:		İ									
Unapproved			<u> </u>				<u> </u>						
						F	AUI	T CATE	GORY				
Landi	ng (Gear			`,	General		-	~		_		1
		Bending				Bend	\perp	Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
1		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct l	Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Power Loss/Surge

Part Moved
Positioned Wrong

Turning Sequence
Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

		자 기	CE	HAWKESBURY, ONTARIO, CA
	CHOKE THOMES	Ê	APPROVED	DRAWING NO.
	_	PH	+	D2174
`	3LVO		•	TILLE
	06.0	06.09.25		WEB ASSEMBLY
	Α		95.10.25	NEW ISSUE
	В		96.01.18	RE-DRAWN
	C		00.09.11	UPDATE FINISH SPEC.
	D		04.06.03	RE-DESIGN
	П		06.09.25	INC 4 HOLES TO \$0.172; CHG

SHEET 1 OF 2

SCALE

REV. E

======		 	D2175-2 - ANGLE D2175-1 ANGLE	
	°	D2 W	D2175-1 ANGLE	
		MS20470AD4-6 RIVET (19 PLS) 	AN526CB32R14 SCREW AN960JD8 WASHER (1) MS21042L08 NUT (1) INSTALL LOOSE (4 HOLES)	(1)
P/N 2174-041	DESCRIPTION WEB ASSEMBLY		(4 Holds) E	
2174-1 2175-2	WEB ANGLE			J

Χ D2 D2 D2 D2175-1 **ANGLE** AN526C832R14 SCREW AN960JD8 WASHER MS21042L08 NUT MS20470AD4-6 RIVET 19

10629Y MJ

ELEASE

HARDWARE

NOTES:

QTY -041

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PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

RF	CE	
CHECKED,	APPROVED	DRAWING N
FF.	*	D2174
DATE		TIME
06.09.25		WEB

SHEET 2 OF 2

-	6.250
R0.35 (TYP)	3.012 1.529 E
4.283 0.500 — 2.692 0.900	GRAIN DIRECTION 6.400 0.821 (TYP)
1.075	#0.128 (22 HOLES) 0.300 1.375
0.550	11.550 (1.050 PITCH)

D2174-1

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DOCUMENT

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PURPOSE

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- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063) 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 5) ALL DIMENSION ARE IN INCHES